

Keprint Ship 25 August.

Work Order ID 161596

161596

Page 1

Item ID: D4308-042BL

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Step, RH Crew

Start Date: 8/14/2017 Start Qty: 8.00

8

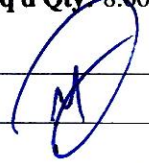
Cust Item ID:

Required Date: 8/23/2017 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan:  Date: AUG 10 2017

Tooling:

Date:

Run Start *NR1*

QC: Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4308	A								

100 0.00

100

Large Fab

Large Fab

Memo

1.52

Large Fab

1-Cut D4308-1 using D2622 extrusion as per Dwg D4308
2-Drill, c'sink one hole on top of step as per dwg
3-Deburr and bevel ends for welding

8x Dr 2017-08-11

110

QC6- All purchased or subcontracted products

0.00

110

QC

Memo

0.00

Quality Control

8 DAS 38 9-89 AUG 11 2017

120

Weld per dwg A/R Aluminum rod Batch: 4130137 0.00

120

Large Fab

Large Fab

Memo

2.16

Large Fab

1-Weld end cap (ONE END ONLY)
2-Grind end cap welds flush
3-weld lugs as per Dwg D4308

8x DAS 43 9-89 AUG 17 2017

Work Order ID 161596

Thursday, August 10, 2017 3:52:29 PM

161596

Page 2

Item ID: D4308-042BL**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** Step, RH Crew**Start Date:** 8/14/2017 **Start Qty:** 8.00***8*****Cust Item ID:****Required Date:** 8/23/2017 **Req'd Qty:** 8.00***8*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.16							
Quality Control									
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	0.16							
Hand Finishing									

③ 11-08-17 PD

⑧ 11-08-17 PD.

⑧ 2017-08-17
JSL
BEB

Work Order ID 161596

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161596

Page 3

Item ID: D4308-042BL

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step, RH Crew

Start Date: 8/14/2017 Start Qty: 8.00

8

Cust Item ID:

Required Date: 8/23/2017 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC7-Inspect Chemical Conversion Coat	0.00							
160									
QC	Memo	0.08							
Quality Control									
170	Weld per dwg A/R Aluminum rod Batch: 4130137	0.00							
170									
Large Fab	Large Fab								
Large Fab	Memo	1.68							
	1-Inspect for foreign object per QSI 024								
	2-Weld Remainig end cap as per Dwg D4308								
	3-Grind end cap weld flush as per dwg D2841								
	4- install rivert as per dwg								
180	QC10- Inspect visual per QSI004- ground welds	0.00							
180									
QC	Memo	0.00							
Quality Control									

8 17-08-18 PD**8x** DAS **43** 9-89 DAS **24** 9-89 **AUG 18 2017****8** DAS **38** 9-89 **AUG 21 2017**

Work Order ID 161596

Thursday, August 10, 2017 3:52:29 PM

161596

Page 4

Item ID: D4308-042BL

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Step, RH Crew

Start Date: 8/14/2017 Start Qty: 8.00

8

Cust Item ID:

Required Date: 8/23/2017 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.16

Quality Control

8

OAS
38
9-89

AUG 21 2017

200

Chemical Conversion Coat per QSI005 4.1

0.00

200

HandFinish

Memo

0.48

Hand Finishing

8

2017-08-21

JSC

B-73

1615.96

Thursday, August 10, 2017 3:52:29 PM

N900040100

Setup Start *NS1*

Stop *NS2*

8

Cust Item ID:

Start Date: 8/14/2017 **Start Qty:** 8.00

8

Customer:

Required Date: 8/23/2017 **Req'd Qty:** 8.00

Reference:

Run Start *NB1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NB2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

213

QC14- Inspect Spray Paint

0.00

213

OC

Memo

0.00

Quality Control

AUG 25 2017

215

Wing Walk as per dwg QSI005 4.4 Batch M137946 0.00

0.00

215

HandFinish

Memo

1.54

Hand Finishing

XPRH ~~_____~~ 20/08/28
BIB

220

QC3- Inspect Part Finish

0.00

220

OC

Memo

0.08

Quality Control

AUG 29 2017

Work Order ID 161596

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161596

Page 7

Item ID: D4308-042BL

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Step, RH Crew

Start Date: 8/14/2017 Start Qty: 8.00 *8*

Cust Item ID:

Required Date: 8/23/2017 Req'd Qty: 8.00 *8*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	Identify as per dwg & Stock Location: <u>51-535</u>	0.00				<u>8</u>			
230									
Packaging	Memo	0.08							
Packaging									
240	QC21- Final Inspection - Work Order Release	0.00							
240									
QC	Memo	0.80							
Quality Control									

AUG 29 2017

DAS
6
9-89

DAS
21
9-89

AUG 29 2017

Picklist Print

Thursday, August 10, 2017 3:52:28 PM

Page 1

Work Order ID: 161596

161596

Parent Item: D4308-042BL

D4308-042BL

Parent Item Name: Step, RH Crew

Start Date: 8/14/2017

Required Date: 8/23/2017

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 11.01.07 new issue DD verf:EC
15.10.13 ADDED BL DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2622-120C		Manufactured	No			100	Each	225.0000	0.05	0.4			
------------	--	--------------	----	--	--	-----	------	----------	------	-----	--	--	--

D2622-120C

Step Extrusion

** 2017-08-11

Location

Loc Qty

Loc Code

WA003

225

15777

0.5

162484

225

162484

D2734

Manufactured

No

120

Each

75.0000

1

8

DAS

43

9-89

AUG 18 2017

D2734

Step End Plate

** B164510 → 8x

Location

Loc Qty

Loc Code

WA003

75

161519

35

164510

40

D2734

Manufactured

No

170

Each

75.0000

1

8

DAS

43

9-89

AUG 18 2017

D2734

Step End Plate

** B164510 → 8x

Location

Loc Qty

Loc Code

WA003

75

161519

35

164510

40

D3458-1

Manufactured

No

120

Each

21.0000

1

8

DAS

43

9-89

AUG 18 2017

D3458-1

Step Mounting Plate

** B159573 → 8x

Location

Loc Qty

Loc Code

WA003

21

159573

21

Picklist Print

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Page 2

Work Order ID: 161596

161596

Parent Item: D4308-042BL

***D4308-042BL ***

Parent Item Name: Step, RH Crew

Start Date: 8/14/2017

Required Date: 8/23/2017

Start Qty: 8.00

Required Qty: 8.00

D3458-3

Manufactured No

120

Each

22.0000

1 8

DAS

D3458-3

Step Mounting Plate

****B159574 → 843 9-89 AUG 18 2017**

Location

Loc Qty

Loc Code

WA003

22

159574

22

MS20601-AD4W2

Purchased

No

170

Each

91.0000

1 8

DAS

MS20601-AD4W2

Rivet

**** 43 9-89 AUG 18 2017**

Location

Loc Qty

Loc Code

ST308

68

m137361

3

m137820

65

WA003

23

m134134

5

m137361

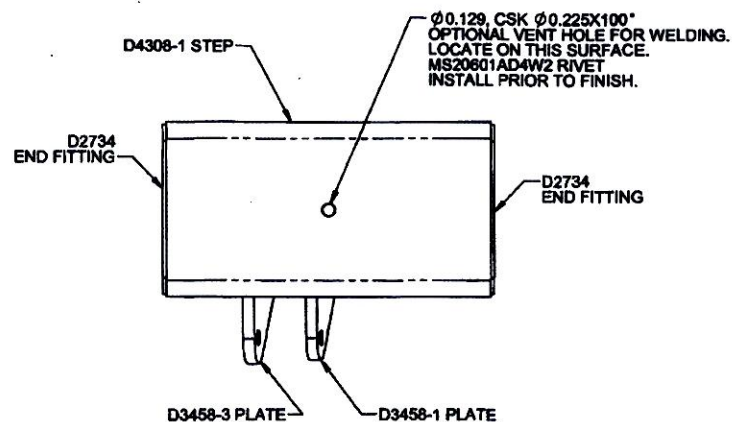
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Thursday, August 10, 2017 3:52:28 PM

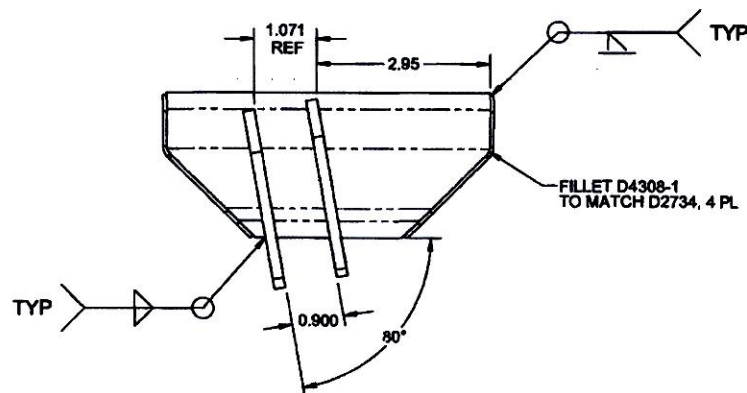
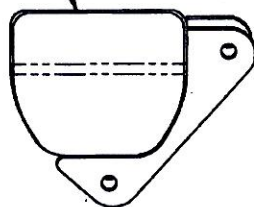
Shop Packet Print

Page 2

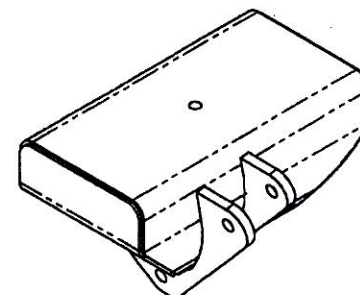
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1	X	D4308-041	STEP, LH CREW
2	1	D4308-1	STEP
3	2	D2734	END PLATE
4	1	D3458-1	PLATE
5	1	D3458-3	PLATE
6	1	MS20601AD4W2	RIVET (OPTIONAL)



2 APPLY BLACK ANTI-SKID ON TOP SURFACE TO BOTTOM OF TOP RADIUS



D4308-041 STEP, LH CREW



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 161506ND
AUG 10 2017

RELEASED
2011-05-26
JW

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N & B/N PER DART QSI 044 6.6 (REMOVABLE TAG)
- 7) WEIGHT: 0.47 lb
- 8) WELDING: PER DART QSI 004

REV.	NEW ISSUE	CP	10.12.17
DESIGN	DESCRIPTION	BY	DATE
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.17		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

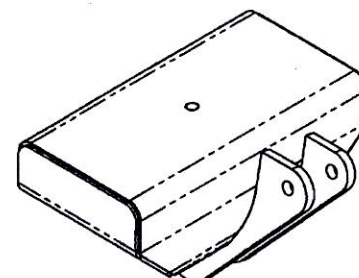
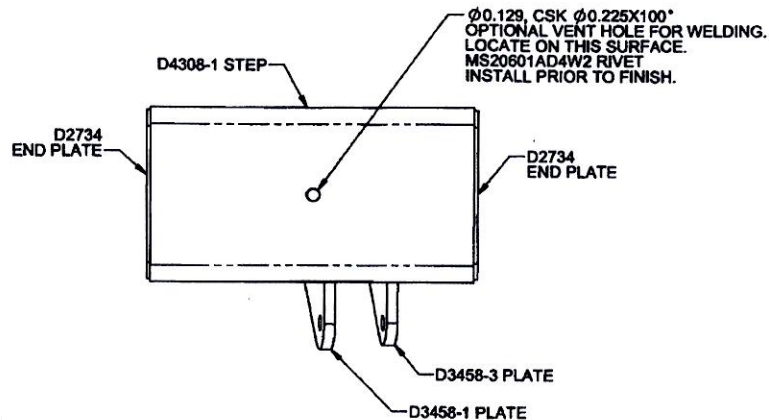
DRAWING NO.
D4308

TITLE
STEP, CREW

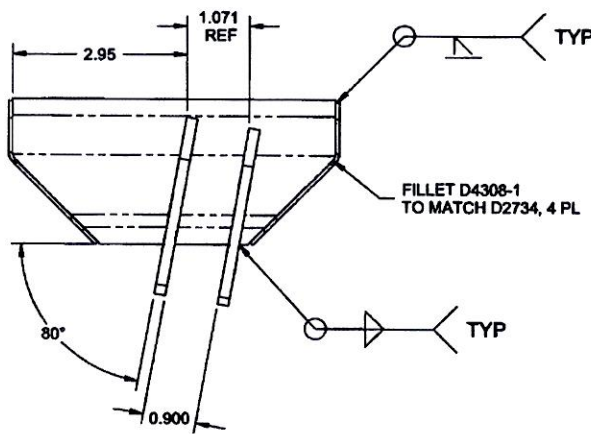
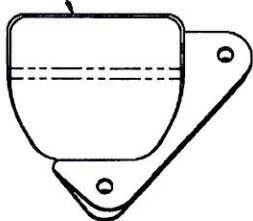
REV. A
SHEET 1 OF 3
SCALE
NTS

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ITEM	QTY	P/N	DESCRIPTION
1	X	D4308-042	STEP, RH CREW
2	1	D4308-1	STEP
3	2	D2734	END PLATE
4	1	D3458-1	PLATE
5	1	D3458-3	PLATE
6	1	MS20601AD4W2	RIVET (OPTIONAL)



2 APPLY BLACK ANTI-SKID ON TOP SURFACE TO BOTTOM OF TOP RADIUS

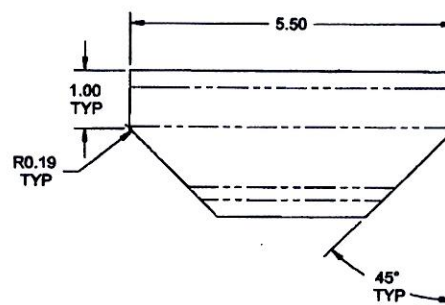
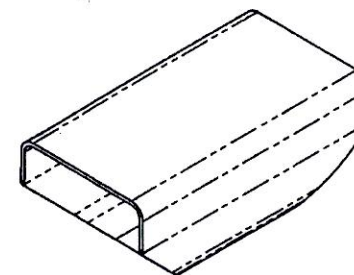
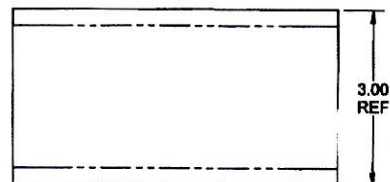
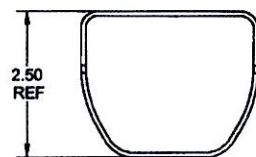


D4308-042 STEP, RH CREW

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: P/N & B/N PER DART QSI 044 6.6 (REMOVABLE TAG)
 - 7) WEIGHT: 0.47 lbs
 - 8) WELDING: PER DART QSI 004

RELEASED
2011-05-24
AM

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4308	REV. A
MFG. APPR.		TITLE STEP, CREW	SHEET 2 OF 3
APPROVED		SCALE	NTS
DE APPR.		COPYRIGHT © 2016 BY DART AEROSPACE LTD	
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D4308-1 STEP

RELEASED
2011-05-20
JMO

NOTES:

- 1) MATERIAL: MAKE FROM D2622 EXTRUSION
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.33 lbs

DESIGN	GP	DART AEROSPACE LTD	
DRAWN	GP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.	ASS	D4308	SHEET 3 OF 3
APPROVED	ASS	TITLE	SCALE
DE APPR.	ASS	STEP, CREW	NTS
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO37518**

Purchase Order Date 8/22/2017

PO Print Date 8/23/2017

Page Number 2 of 5

Order From :

VC-ATE001

Ship To : DART AEROSPACE LTD

ATELIER DEBOSSELAGE
358 PRINCIPALE
CALUMET, QC J0V 1B0
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

819 242 5633

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Buyer

Diane Baker

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Total: \$360.00

4 161596 D4308-042BL Step, RH 8/24/2017

Crew

No

8/24/2017

Prime and Paint Deflect Blue

8.00

\$40.00

\$320.00

Line Total: \$320.00

5 162185 D206-667-107BL Fwd 8/24/2017

Crosstube

No

8/24/2017

Prime and Paint Deflect Blue

1.00

\$225.00

\$225.00

Line Total: \$225.00

6 162186 D206-667-107BL Fwd 8/24/2017

Crosstube

No

8/24/2017

Prime and Paint Deflect Blue

1.00

\$225.00

\$225.00

Note:

8/23/2017